

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-013928**Date Inspected:** 08-May-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Yang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

This QA inspector performed MT of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT report for this date. The member(s) is/are identified as BP cantilevers. The weld designations reviewed are as follows:

1. BK001-027-024
2. BK001-026-024
3. BK001-025-024
4. BK001-029-024
5. BK001-028-025

8AE

Shield Metal Arc Welding (SMAW) repair welding was performed on weld joint 013 located at SEG044C counter weight side of segment. Welder is identified as Mr. Wang Zhonghua (053753). ZPMC QC is identified as Wu Zhi Cheng. The welding variables monitored and recorded by the QC appeared to comply with WPS-345-SMAW-3G (3F)-Repair-1 and WR12877 procedure.

8AW

Shield Metal Arc Welding (SMAW) welding was performed on weld joint 031~42 located at BP148-001 bottom plate of segment. Welder is identified as Mr. Wei Hengbin (068924). ZPMC QC is identified as Wu Zhi Cheng.

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The welding variables monitored and recorded by the QC appeared to comply with WPS-B-P-2112-FCM-1.

7EW

Shield Metal Arc Welding (SMAW) welding was performed on weld joint 031~42 located at BP147-001 bottom plate of segment. Welder is identified as Mr. Wei Hengbin (068924). ZPMC QC is identified as Wu Zhi Cheng. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-P-2112-FCM-1.

7DW

Shield Metal Arc Welding (SMAW) repair welding was performed on weld joint 002 located at OBW8B cross beam side of segment. Welder is identified as Mr. Xu Changxue (066002). ZPMC QC is identified as Wu Zhi Cheng. The welding variables monitored and recorded by the QC appeared to comply with WPS-345-SMAW-3G (3F)-FCM-Repair-1 and WR 12418 procedure.

7EE

Shield Metal Arc Welding (SMAW) repair welding was performed on weld joint 006 located at CA046-001 bike path side of segment. Welder is identified as Mr. Han Xiaofeng (054467). ZPMC QC is identified as Wu Zhi Cheng. The welding variables monitored and recorded by the QC appeared to comply with WPS-345-2G (2F)-FCM –Repair-1 and CWR1471 procedure.

Y Location of repairs areas by above noted welder (054467) is located at 13320~13550, 12760~12800 and 13065~13140mm.

7DW+7EW

Shield Metal Arc Welding (SMAW) welding was performed on weld joint 031~035 located at SP432-001 counter weight side of segment. Welder is identified as Mr. Zang Wei (066413). ZPMC QC is identified as Wu Zhi Cheng. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-P-2214-B-U2-FCM-1.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang (150-0042-2372), who represents the Office of Structural Materials for your project.

Inspected By: Alaniz,Joe

Quality Assurance Inspector

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Reviewed By: Carreon,Albert

QA Reviewer